



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D350-636-015
Job Sheet 200933



Part No: D350-636-015

Job Qty: 1 pcs

Part Name: Skidtube LH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/25/19

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG D4168-041 REV.C IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:F 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/25/19		0.00	5.25	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	10/25/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	10/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		



Container No: S216473



Part: D350-636-015

Job No: 200933

Serial No/Batch: S216473

Revision: C

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17 TC STC SH

Dart Aerospace Ltd.
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140 Handfinish - 1-1 Chemical-B4B	1 pcs	10/25/19	0.00 0.99	QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	CL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 25 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
150 QC 7	1 pcs	10/25/19	0.00 0.00	Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	

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[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MLG
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
160 Skidtubes - 2 - B4B	1 pcs	10/25/19	0.00 5.25	1:30TF 3:02TF 14R44	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
170 QC 10	1 pcs	10/25/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
180 QC 5	1 pcs	10/25/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/25/19	0.00 0.33		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	

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[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

200 Spray Paint - 2 - B4B	1 pcs	10/25/19	0.00 0.91	Handfinish - 2 - 4 - B4B	DAS
				Spray Paint - 1 - B4B	41 OCT 24 2019
				Spray Paint - 2 - B4B	3-89
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
210 QC 14	1 pcs	10/25/19	0.00 0.00	QC 14 - 15	QC 14 - 10 - 25
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	10/25/19	0.00 0.99	Handfinish - 4 - 1 - B4B	QC 14 - 10 - 25
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
240 QC 5	1 pcs	10/25/19	0.00 0.00	Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

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250	Packaging 1-1 - Pick Kit - B4B	1 pcs	10/25/19	0.00 0.00	QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	PC
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
260	QC 4	1 pcs	10/25/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
270	Packaging 3-1 - Stock - B4B	1 pcs	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	10/25/19	0.00 0.00	DC - 1 - B4B	DAS 21
	pcs			DC - 2 - B4B	NOV 20 2019
280 QC 21 - FG	1	10/25/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	DAS 21 NOV 20 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "A" 6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 134017 9- Grind welds flush as per Dwg D4168 120 - QC10 (QC10- Inspect visual per QSI004- ground welds) 130 - QC5 (QC5- Inspect part completeness to step on W/O) 140 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) 150 - QC7-2 (QC7-Inspect Chemical Conversion Coat) 160 - (Skidtubes) 1-Open up holes using hole saw of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) section AJ-AJ Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG 4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: _____ exp. date: _____ ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on sheet 8)

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- A/R Aluminum Rod batch: _____ 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section AL-AL 12-C'bore section CG-CG. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Deburr holes, ensure tube is free of all scratches before sending to paint.
- 170 - QC10 (QC10- Inspect visual per QSI004- ground welds)
- 180 - QC5 (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
- 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
- 200 - Spray Paint (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125
- 210 - QC14 (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
- 230 - HandFinish4 (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5206625 EXP DATE: 20-7-25 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5138543 5-Coat all exposed fasteners with "LPS Procyon" batch: 5133640
- 240 - QC5 (QC5- Inspect part completeness to step on W/O)
- 250 - Packaging1-3 (Pick Kit) If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1
- 260 - QC4 (QC4- 100% Inspect kits for completeness)*****ensure antiseize is on AN8C21A bolts*****
- 270 - Packaging3-1 (Identify as per dwg & Stock Location: F6012) Identify and pack for shipping as per PPPD350-636-015 Location :FG071
- 275 - DC (Document Control) record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-015 CHG 006
- 280 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1	512649
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5127857
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5127857
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5127857
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5127857
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5127857
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5127857
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5127857
AN3C42A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5127857
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5127857
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5127857
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5127857
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5127857
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5127857

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	4	0
	D2744	1	38	0
160-Skidtubes - 2 - B4B	D2739	1	4	0
	D2743	8	369	0
	D3490-1	4	190	0
	D3490-3	4	21	0
	ALS4-1032-225	4	1,872	0
230-Handfinish - 4-1-Assembly-B4B	AN3C34A	1	33	0
	AN3C36A	4	199	0
	AN3C6A	4	95	0
	AN6C44A	4	60	0
	AN8C35A	1	14	0
	D2745	8	104	0
	D3488-3	1	18	0
	D3492-1	8	92	0
	D3492-3	8	50	0
	D3631-1	8	256	0
	D3873-1	7	38	0
	D4154-041	1	7	0
	D4170-1	4	125	0
	D4171-1	1	21	0
	MS21043-3	5	567	0
	MS21043-6	4	48	0
	MS21083C8	1	44	0
	NAS1149C0332R	4	2,920	0
	NAS1149C0363R	9	549	0
	NAS1149C0832R	1	267	0
	NAS1515H3L	4	243	0
	NAS1611-010	8	131	0
	NAS1611-013	8	128	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	79	0
	AN3C42A	1	71	0
	AN8C21A	2	81	0
	D2741	1	65	0
	D3493-1	2	37	0
	MS21083C8	2	44	0
	NAS1149D0863J	2	325	0
Part Specifications				
Specifications could not be found.				

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QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	P/N	DESCRIPTION
X					D4108-041	350 SKIDTUBE ASSEMBLY, LH
	X				D4108-042	350 SKIDTUBE ASSEMBLY, RH
		X			D4108-043	350 SKIDTUBE ASSEMBLY, LH
			X		D4108-044	350 SKIDTUBE ASSEMBLY, RH
				X	D4108-051	350 SKIDTUBE ASSEMBLY, LH
					D4108-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	D2730	WEB
8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	D2744	CAP
8	8	8	8	8	D2745	BUSHING
1	1	1	1	1	D3460-3	BLADE FITTING, LH
4	4	4	4	4	D3460-4	BLADE FITTING, RH
4	4	4	4	4	D3460-1	CROSS BOLT SPACER
4	4	4	4	4	D3460-3	CROSS BOLT SPACER
8	8	8	8	8	D3462-041	PLUG ASSEMBLY
8	8	8	8	8	D3462-043	PLUG ASSEMBLY
8	8	8	8	8	D3462-045	PLUG ASSEMBLY
7	7	7	7	7	D3473-1	WASHER
1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1	1	1	1	1	D4168-1	SKIDTUBE WELDMENT, LH
1	1	1	1	1	D4168-2	SKIDTUBE WELDMENT, RH
1	1	1	1	1	D4168-3	SKIDTUBE WELDMENT, LH
1	1	1	1	1	D4168-4	SKIDTUBE WELDMENT, RH
1	1	1	1	1	D4168-5	SKIDTUBE WELDMENT, LH
1	1	1	1	1	D4168-6	SKIDTUBE WELDMENT, RH
1	1	1	1	1	D4171-1	SPACER
1	1	1	1	1	D4171-1	BUSHING
4	4	4	4	4	ALS-1032-225	INSERT
1	1	1	1	1	AN3C34A	BOLT
4	4	4	4	4	AN3C36A	BOLT
4	4	4	4	4	AN3C38A	BOLT
4	4	4	4	4	AN3C40A	BOLT
4	4	4	4	4	AN3C42A	BOLT
4	4	4	4	4	AN3C35A	BOLT
5	5	5	5	5	MS21043-5	NUT
1	1	1	1	1	MS21043-5	NUT
1	1	1	1	1	MS21089-3	NUT
4	4	4	4	4	NAS1146C0302R	WASHER
9	9	9	9	9	NAS1146C0303R	WASHER
1	1	1	1	1	NAS1146C0302R	WASHER
4	4	4	4	4	NAS1146C0303R	WASHER

NOTES:

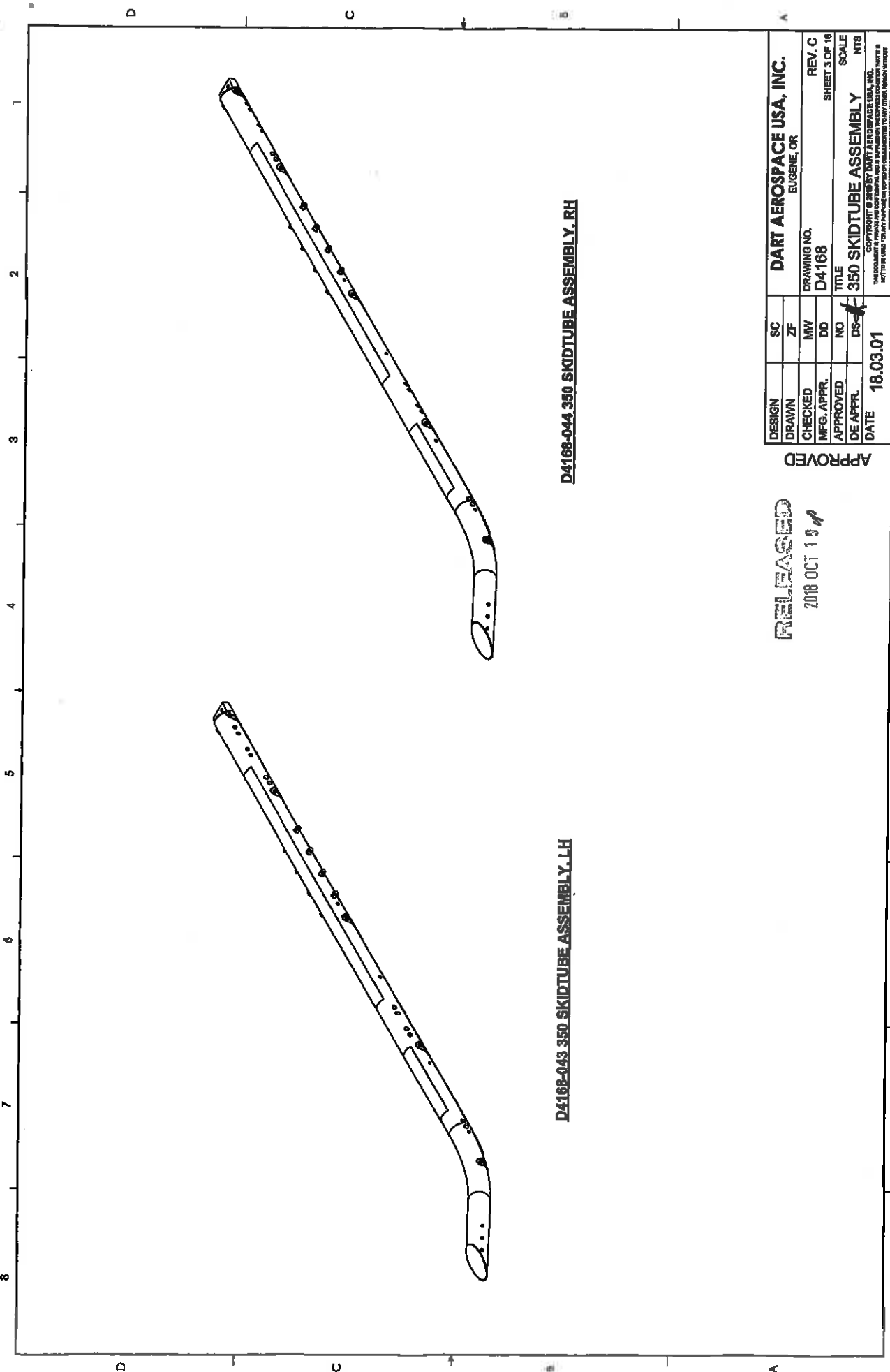
- 1) MATERIAL: MAKE D4168-1/-2/-3/-4/-5/-6 FROM D2800-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2738 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-051/-052 = 32.3 lbs
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES: MINIMUM YIELD TENSILE STRENGTH = 35 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCOYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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C	ADDED -051/-052 (ZN D6-1 SHEETS 4, 15-16) ADDED D4168-046 (ZN D6-1 SHEETS 9, 10) D4168-047 REPLACES D4168-041 ADDED (ZN D6-1, D2-11, D2-12, D2-13, D2-14) ADDED (ZN D6-1, D2-11, D2-12, D2-13, D2-14) AN3C30 (ZN A5-1, C5-1, C7-1, C8-1, C9-1, C10-1, C11-1, C12-1, C13-1, C14-1, C15-1, C16-1, C17-1, C18-1, C19-1, C20-1, C21-1, C22-1, C23-1, C24-1, C25-1, C26-1, C27-1, C28-1, C29-1, C30-1, C31-1, C32-1, C33-1, C34-1, C35-1, C36-1, C37-1, C38-1, C39-1, C40-1, C41-1, C42-1, C43-1, C44-1, C45-1, C46-1, C47-1, C48-1, C49-1, C50-1, C51-1, C52-1, C53-1, C54-1, C55-1, C56-1, C57-1, C58-1, C59-1, C60-1, C61-1, C62-1, C63-1, C64-1, C65-1, C66-1, C67-1, C68-1, C69-1, C70-1, C71-1, C72-1, C73-1, C74-1, C75-1, C76-1, C77-1, C78-1, C79-1, C80-1, C81-1, C82-1, C83-1, C84-1, C85-1, C86-1, C87-1, C88-1, C89-1, C90-1, C91-1, C92-1, C93-1, C94-1, C95-1, C96-1, C97-1, C98-1, C99-1, C100-1, C101-1, C102-1, C103-1, C104-1, C105-1, C106-1, C107-1, C108-1, C109-1, C110-1, C111-1, C112-1, C113-1, C114-1, C115-1, 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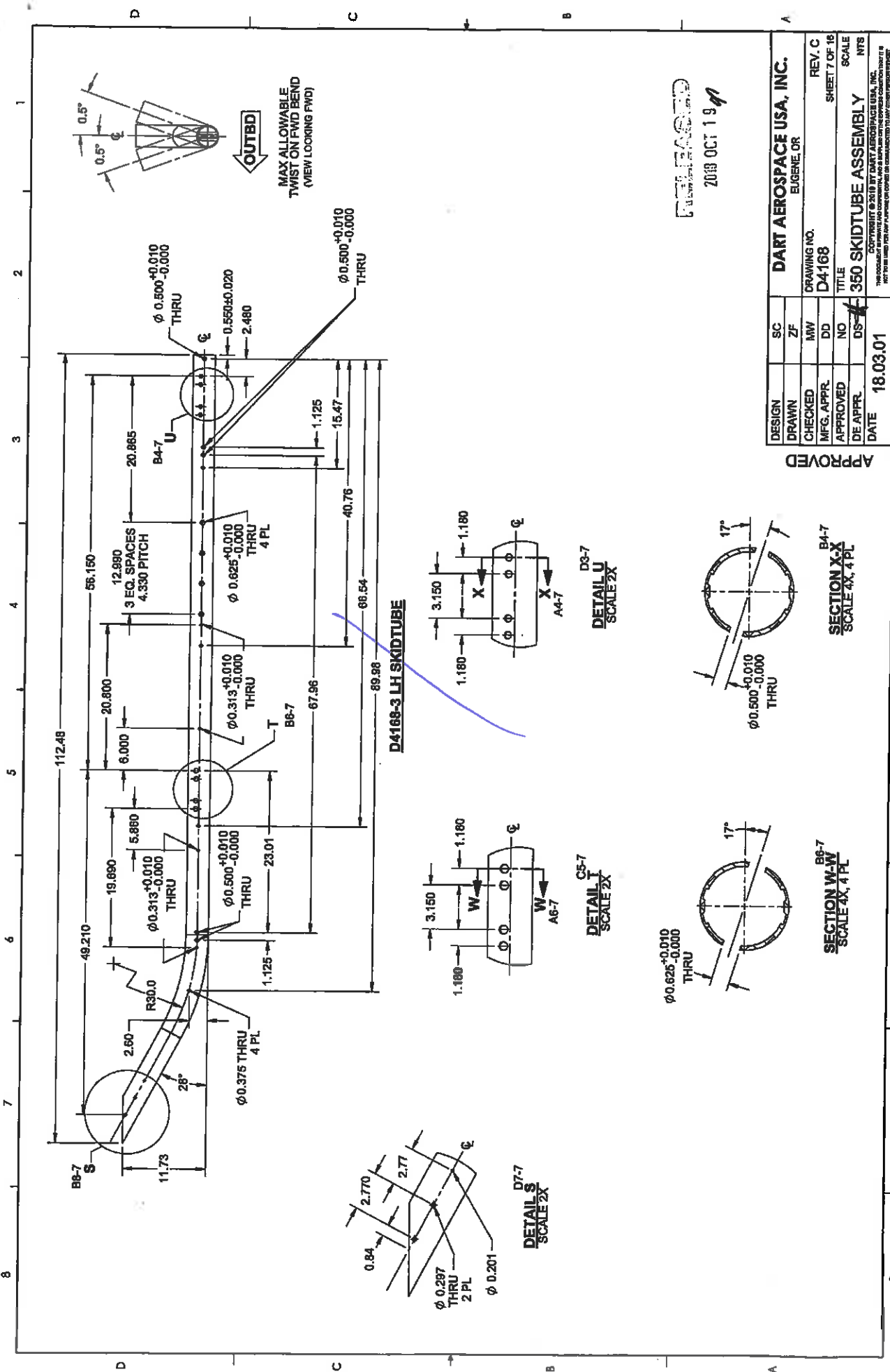
D4168-044 350 SKIDTUBE ASSEMBLY, RH

D4168-043 350 SKIDTUBE ASSEMBLY, LH

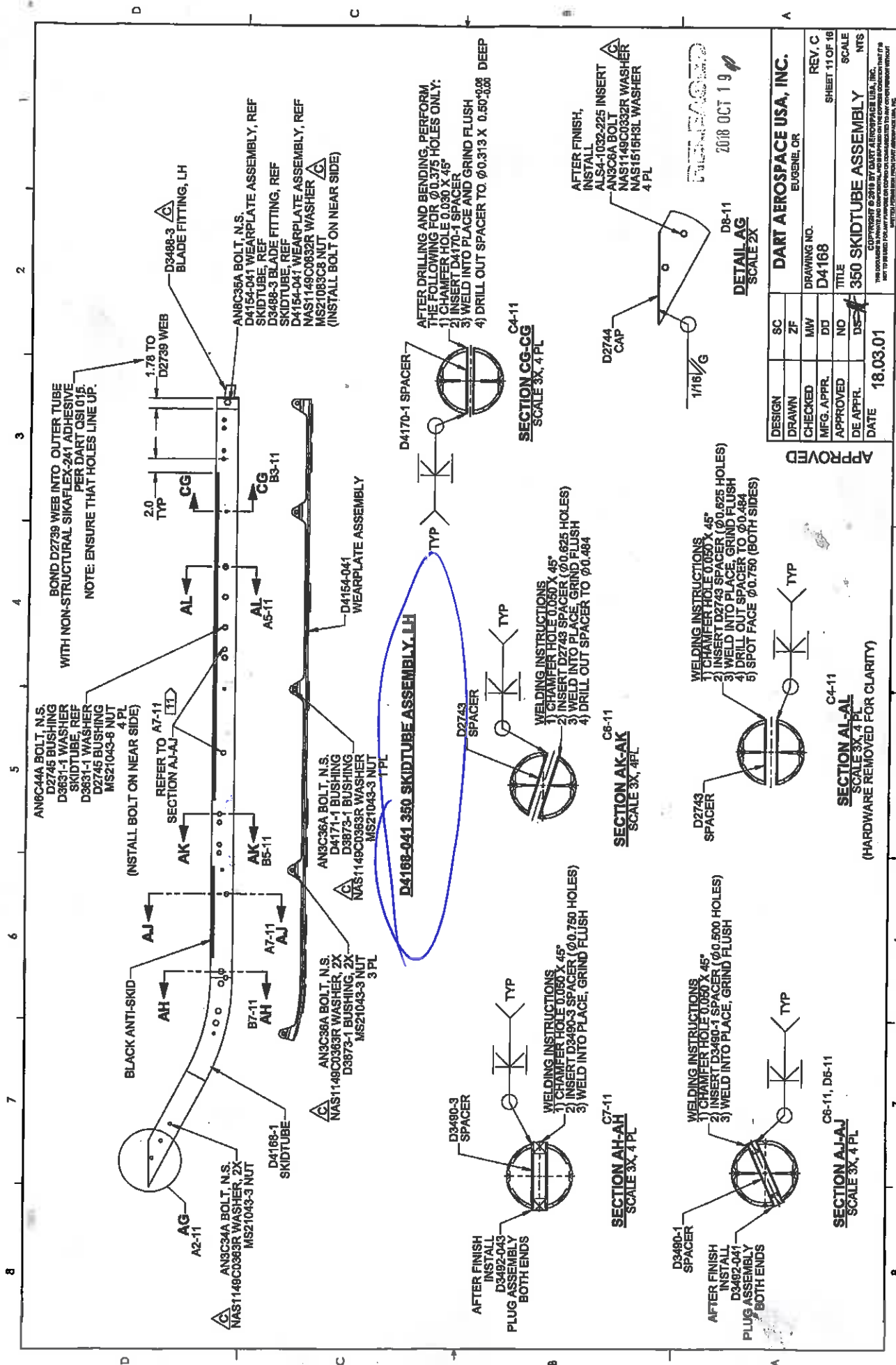
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.	
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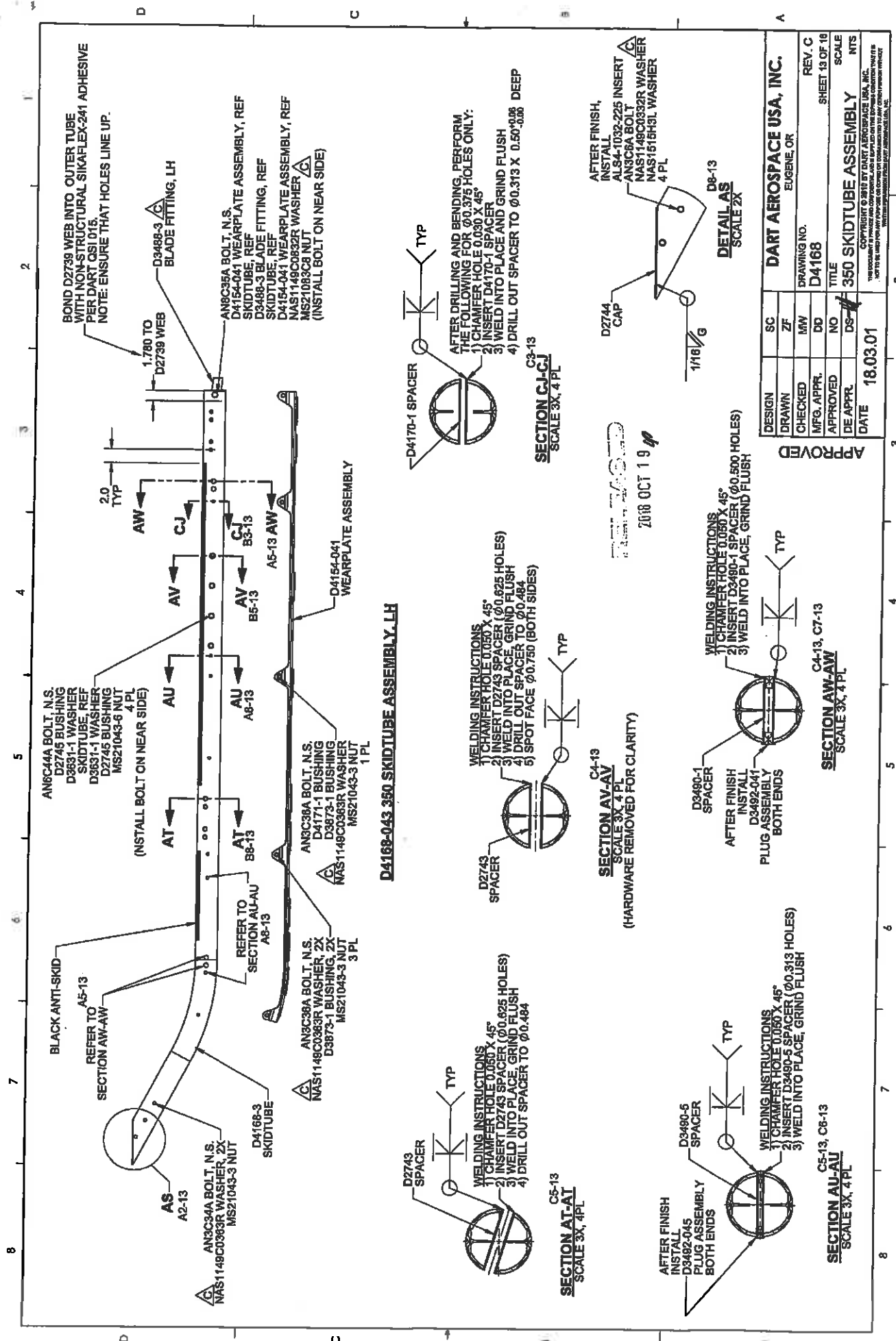
RELEASED
2018 OCT 19

APPROVED



RELEASED
2019 OCT 19





Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

MIRB (QS1042)

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐
Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Other/Details: _____

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
*1	1					1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1		1						D4168-1	SKIDTUBE WELDMENT, LH
*1			1					D4168-2	SKIDTUBE WELDMENT, RH
*1				1				D4168-3	SKIDTUBE WELDMENT, LH
*1					1			D4168-4	SKIDTUBE WELDMENT, RH
*1						1		D4168-5	SKIDTUBE WELDMENT, LH
							1	D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2745	BLADE
10	2	2	2	2	2	2		AN6C44A	BOLT
11	2	2	2	2	2	2		NAS1149CO863	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K

Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C27A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

- ¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS
² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS
³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS
⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS